



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

19-7549
D4583-041
Job Sheet 187087



Part No: D4583-041

Job Qty: 1 ea

Part Name: Door Assembly, Full Vertical Reference Window, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 12.02.15 new issue DD verf:EC IPP REV:B 12.10.12 as per dwg rev.b
DD VERF:JLM IPP REV:C 12.12.04 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Stores/Pkg-1		DAS
100	Packaging	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging1		DAS 36
110	Small Fab	1 pcs	1/31/19	1/31/19	0.00	0.00	Small Fab		36 9-89 DAS
120	QC	1 pcs	1/31/19	1/31/19	0.00	0.00	QC5		APR 02 2019 68
130	Packaging	1 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3		APR 02 2019 9-89
140	QC21-SA	1 Ea	1/31/19	1/31/19	0.00	0.00	QC21		

Part Op
Descriptions: 110 - Assemble as per dwg

Job BOM

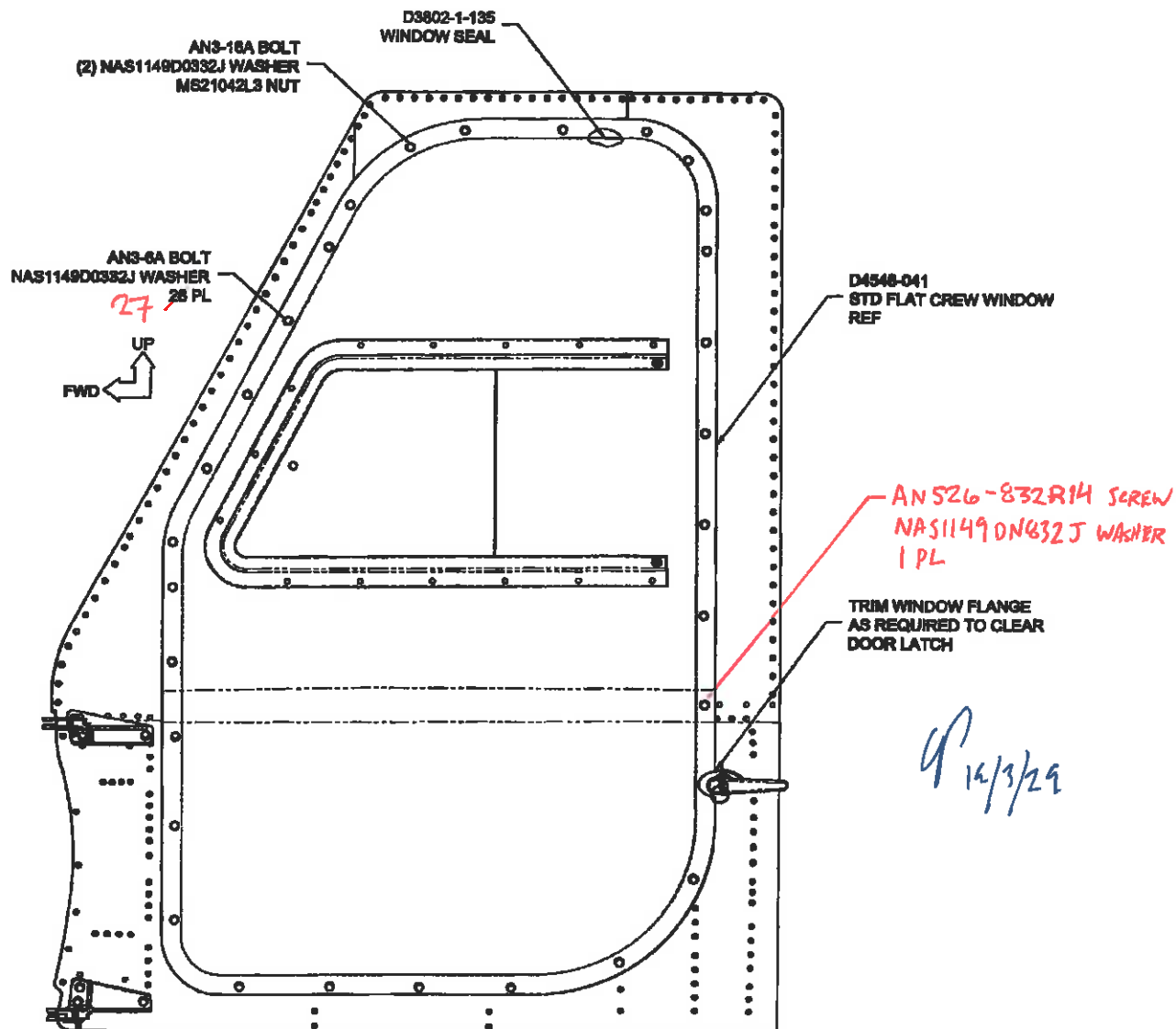
Part / Item	Component Name	Quantity	Operation	Container
AN3-16A	Bolt	1 Ea (1 ea)	90-Start up Operation	5045859
AN3-6A	Bolt	28 Ea (28 ea)	90-Start up Operation	5103950
D3676-1	Bubble Window - LH	1 Ea (1 ea)	90-Start up Operation	5159612
D3802-1-135	Window Seal - 135"	1 Ea (1 ea)	90-Start up Operation	5138462
D4465-041	Medium Bell Door Assembly, LH	1 pcs (1 ea)	90-Start up Operation	5166244
MS21042L3	Nut	1 Ea (1 ea)	90-Start up Operation	5132364
NAS1149D0332J	Washer	30 Ea (30 ea)	90-Start up Operation	5113751

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-16A	1	66	0
	AN3-6A	28	168	0
	D3676-1	1	2	0
	D3802-1-135	1	2	0
	D4465-041	1	0	0
	MS21042L3	1	2,157	0
	NAS1149D0332J	30	1,782	0

Part Specifications

Specifications could not be found.



**Figure 52-2 – D412-814-211/-212/-213/-214/-215/-216/-217/-218/-219/-220/
Window Kits Installation
(D412-814-211 Shown)
(LH Shown, RH Opposite)**

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52-00-00

Revision: 2



Container No: S168882
Part: D4583-041
Job No: 187087
Serial No/Batch: S168882

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/02/19

D4547-041
VERTICAL LINKAGE
REF

AN3-7 BOLT
NAS1149D0332J WASHER
AN310-3 NUT - CASTELLATED
MS24685-1011 COTTER PIN

VIEW E-E B4-3
(SCALE 2X)
(AFT RIB REMOVED FOR CLARITY)

D4570-11
BRACKET
REF

D4570-3 BRACKET (LH)
REF

MS20470AD4-5
RIVET, PAN HEAD
HEAD, FS
3 PL

TRANSFER MARK
FROM D4494-041
AND DRILL $\phi 0.129$
3 PL

MS20800AD4W4
BLIND RIVET
3 PL

D4494-041
UPPER BLOCK ASSEMBLY (LH)
REF

SECTION A-A B5-2
(SCALE 2X)

D4576-041
HORIZONTAL LINKAGE ASSY (LH)

D4547-041
VERTICAL LINKAGE

CR3213-4-04
RIVET
7 PL

TRANSFER MARK FROM
D4576-041 TO D4500-1
AND DRILL $\phi 0.129$
7 PL

D2463-1640 NEOPRENE SEAL
APPLY AROUND PERIMETER
OF DOOR, TRIM AS REQUIRED

MS20470AD4-4
RIVET, PAN HEAD
3 PL

D4522-041
DOOR LATCH ASSY, (LH)

MS24694-S5 SCREW
9 PL

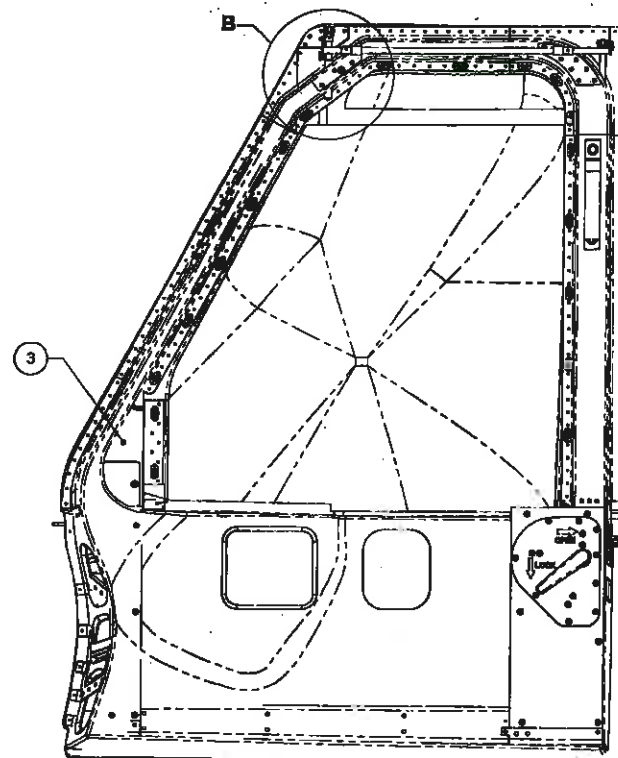
CR3213-4-04
RIVET
5 PL

TRANSFER MARK FROM
D4576-041 TO D4500-1
AND DRILL $\phi 0.129$
5 PL



RELEASED
2012-11-29

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P	DRAWING NO.	REV. C
MFG. APPR.	12	D4465	SHEET 3 OF 8
APPROVED	12	TITLE	SCALE
DE APPR.	12	MED BELL DOOR ASSY	NTS
DATE	12.10.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



LOCATE APPROX AS SHOWN
DRILL $\varnothing 0.195 - \varnothing 0.201$ THRU
STRUCTURE WINDOW AND DOOR

6 7 7 5

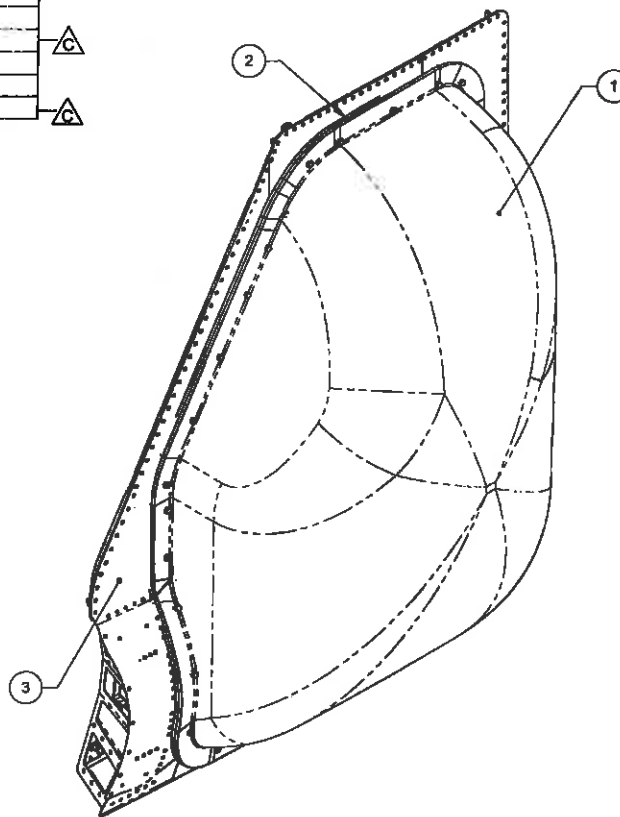
0.3 2.0

DETAIL B
SCALE 2X

RELEASE
2012-11-29
mp

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4583 TITLE DOOR ASSY, FULL VERT REF WINDOW COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED TO SCALE AND IS NOT TO BE USED FOR ANY PURPOSE OR USED OR CONSIDERED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C
DRAWN	AJS		SHEET 4 OF 4
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.10.16		

ITEM	QTY	P/N	DESCRIPTION
	X	D4583-041	DOOR ASSY, FULL VERT REF WINDOW (LH)
1	1	D3876-1	412 BUBBLE WINDOW
2	1	D3802-1-135	WINDOW SEAL
3	1	D4465-041	MED BELL DOOR ASSY (LH)
4	28	AN3-6A	BOLT
5	1	AN3-16A	BOLT
6	1	MS21042L3	NUT
7	30	NAS1149D0332J	WASHER



D4583-041 DOOR ASSY, FULL VERT REF WINDOW (LH)

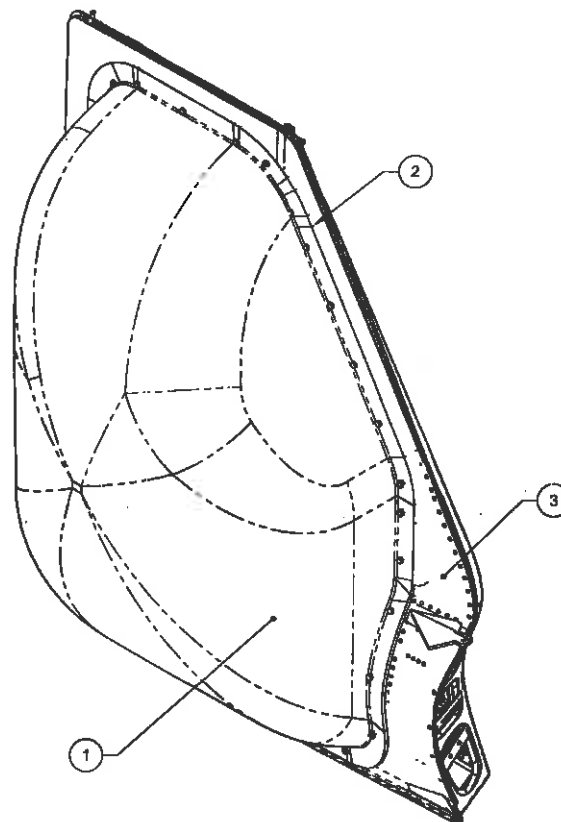
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.2 LBS (ESTIMATED)

RELEASE
2012-11-29

REV.	DESCRIPTION	BY	DATE
C	ADDED -042 (RH CONFIGURATION). 1 WINDOW FASTENER DELETED.	AJS	12.10.16
B	VIEWS UPDATED FOR REDESIGNED DOOR STRUCTURE.	AJS	12.09.11
A	NEW ISSUE	AJS	12.02.29
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4583	8 SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR ASSY, FULL VERT REF WINDOW	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D4583-042	DOOR ASSY, FULL VERT REF WINDOW (RH)
1	1	D3676-2	FULL HEIGHT BUBBLE WINDOW (RH)
2	1	D3802-1-135	WINDOW SEAL
3	1	D4465-042	MED BELL DOOR ASSY (RH)
4	28	AN3-8A	BOLT
5	1	AN3-16A	BOLT
6	1	MS21042L3	NUT
7	30	NAS1149D0332J	WASHER



D4583-042 DOOR ASSY, FULL VERT REF WINDOW (RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.2 LBS (ESTIMATED)

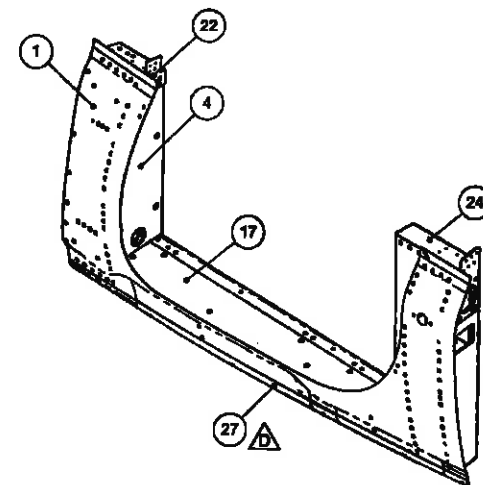
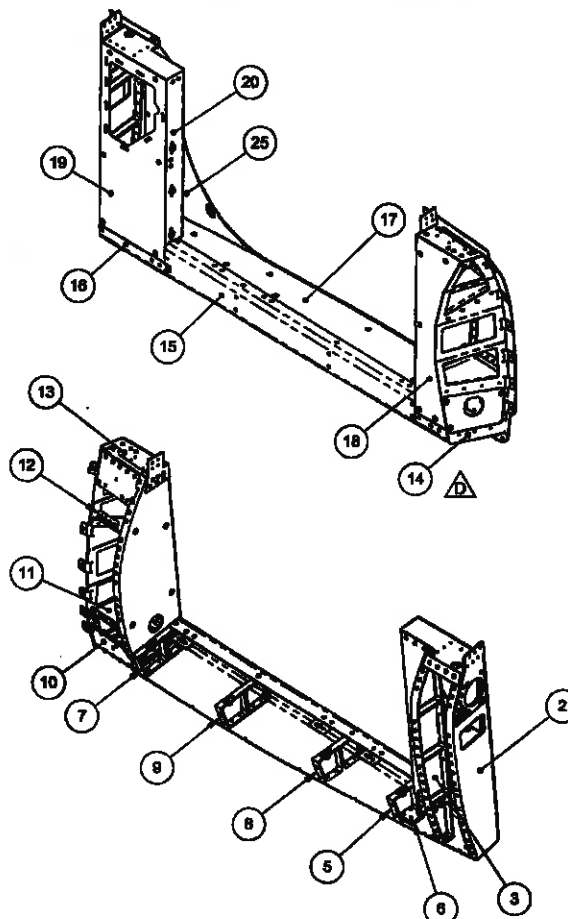
RELEASED
2012-11-29
WHO

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4583	SHEET 3 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	DOOR ASSY, FULL VERT REF WINDOW	NTS
DATE	12.10.16	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D4467-041	LOWER DOOR ASSY (LH)
1	1	D4469-1	OUTER SKIN LOWER DOOR
2	1	D4470-041	AFT RIB ASSY (LH)
3	1	D4471-041	MID RIB ASSY (LH)
4	1	D4472-041	FWD RIB ASSY (LH)
5	1	D4473-041	SMALL RIB ASSY (LH)
6	1	D4474-1	SPLICE BLOCK
7	1	D4475-041	SMALL RIB ASSY
8	1	D4476-041	SMALL RIB ASSY (LH)
9	1	D4477-041	SMALL RIB ASSY
10	1	D4478-041	INTERCOSTAL 1 ASSY (LH)
11	1	D4479-041	INTERCOSTAL 2 ASSY (LH)
12	1	D4481-041	INTERCOSTAL 4 ASSY (LH)
13	1	D4482-041	INTERCOSTAL 5 ASSY (LH)
14	1	D4483-041	FWD CLOSEOUT PANEL ASSY (LH)
15	1	D4484-041	BOTTOM PANEL ASSY (LH)
16	1	D4484-043	AFT BOTTOM PANEL ASSY (LH)
17	1	D4485-1	LOWER CLOSEOUT PANEL
18	1	D4486-3	FWD ACCESS PANEL (LH)
19	1	D4486-041	ACCESS PANEL ASSY (LH)
20	1	D4487-041	CLOSEOUT PANEL ASSY (LH)
21	1	D4488-5	ANGLE CLIP
22	1	D4490-1	SPLICE PLATE
22	1	D4490-3	SPLICE PLATE
24	1	D4494-041	UPPER BLOCK ASSEMBLY (LH)
25	1	D4621-1	DOUBLER (LOWER DOOR)
26	1	D4570-5	BRACKET
27	1	D4759-1	SCUFF STRIP
28	54	MS20426AD3-3	RIVET, CSK
29	18	MS20426AD3-4	RIVET, CSK
30	3	MS20426AD4-4	RIVET, CSK
31	38	MS20426AD4-6	RIVET, CSK
32	4	MS20426AD4-8	RIVET, CSK
33	71	MS20470AD4-3	RIVET, PAN HEAD
34	20	MS20470AD4-4	RIVET, PAN HEAD
35	22	MS20470AD4-5	RIVET, PAN HEAD
36	1	MS20470AD4-6	RIVET, PAN HEAD
37	27	MS20801AD4W3	RIVET, CSK BLIND
38	6	MS20615-3M3	RIVET
39	2	MS21043-3	NUT
40	9	MS21059L3K	NUTPLATE
41	1	MS21069L08	NUTPLATE
42	11	MS24694-S4	SCREW
43	7	MS24694-S5	SCREW
44	4	MS24694-S56	SCREW
45	3	MS27039-1-07	SCREW
46	2	MS27039-1-14	SCREW
47	2	MS27039-0807	SCREW
48	2	NAS1149DN832J	WASHER
49	7	NAS1149D0332J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.65 lbs
- 8) INSTALL ALL RIVETS WET USING PROSEAL 890 B-2 (PRC)
- 9) SEAL ALL GAPS ON MATING PARTS USING PROSEAL 890 B-2 (PRC)
- 10) COAT BOTH FACES OF THE D4469-1 SKIN LOCALLY USING PROSEAL 890 B-2 (PRC) PRIOR TO INSTALLATION OF D4759-1 SCUFF STRIP.



D4467-041 LOWER DOOR ASSY (LH)

DEO ATTACHED

RELEASED
2013-02-08

UNDER REVIEW
URF 19-663 19.03.27 (SAD)

D	MULTIPLE UPDATES FOR DESIGN IMPROVEMENT AND EASE OF MANUFACTURE. PICTORIAL UPDATE TO -041 TO SHOW NUTPLATES ADDED TO ITEM 20.		AJS	12.12.20
C	ADD -042 (RH CONFIGURATION)		AJS	12.10.09
B	COMPLETE REDESIGN. SEE REV A FOR DETAILS.		AJS	12.09.10
A	NEW ISSUE		AJS	12.03.01
REV.	DESCRIPTION	BY	DATE	
DESIGN	AJS			
DRAWN	AJS			
CHECKED	AP			
MFG. APPR.	AS			
APPROVED	AP			
DE APPR.	AP			
DATE	12.12.20			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4467** REV. D
SHEET 1 OF 10
SCALE
NTS

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Entered: 2R Date: Oct 24/19



NCR No. 1A-7549

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>187087</u> Part No. <u>104583-041</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date: <u>2019-03-27</u>		Sequence #:		QTY Affected: <u>1</u>		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
One window attachment nutplates is for #8 screws. AN3-6A Bolt will not install. Reason: dwg error				Install (1) AN526C832 R14 M133532 (1) NAS1149DN832J M137587 Engineering will produce DSI to revise 11N/1CA.																															
				Completed By <u>[Signature]</u> 15/3/27 Lead hand / Supervisor <u>[Signature]</u> 19-07-17 QC / QA Coordinator <u>DAS 55</u> 9-89 27 MAR 2019																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																																	